

100		0.00			
100	Hardinge CNC LATHE SMALL				
Hardinge	Memo	0.00			
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA571 & DWG D3454 ,FOLIO REV: <u>14</u> DWG REV: <u>6</u> 2-DEBURR AS REQUIRED				
				12	0 12/01/10
110	QC2- Inspect parts off machine FAI/FAIB	0.00			
110					
QC	Memo	0.00			
Quality Control					
				12	0 12/01/10
120	QC8- Inspect parts - second check	0.00			
120					
QC	Memo	0.00			
Quality Control					
				12	0 12/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77616

77616

Page 2

December-13-11 4:26:36 PM

Item ID: D3454-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 13/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>SI 441</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SP 12-01-12:

12/1/12

mf 12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-13-11 4:26:42 PM

Page 1

Work Order ID: 77616

77616

Parent Item: D3454-3

D3454-3

Parent Item Name: Bushing

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev. A 05.11.17 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	40.1580	0.06	0.757895			

M303R0 750

303 Round Bar 0.750

**

0.617'

12/01/10

Location	Loc Qty	Loc Code
MAT028	40.158	
117328	25.2	
117798	4.004	
118509	9.809	
119346	1.145	

120145

0.617'

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

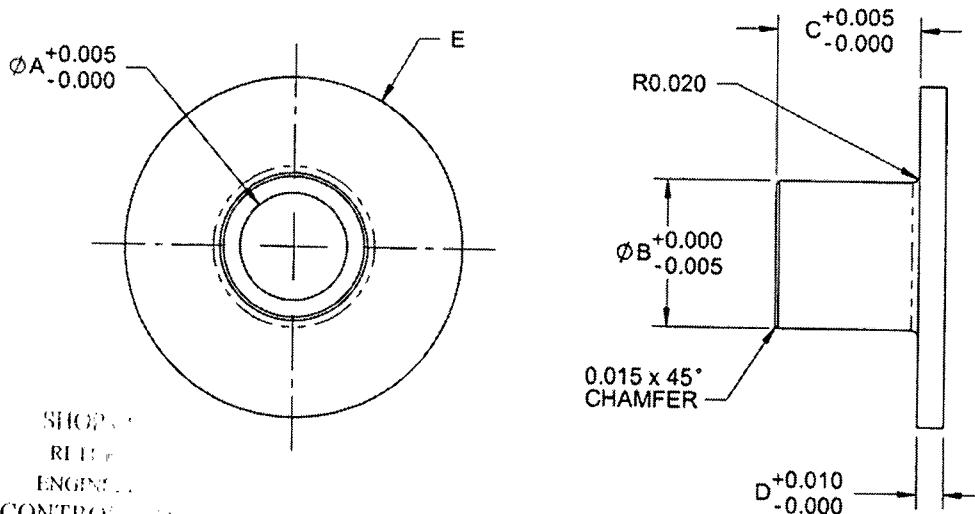
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3454	REV. B SHEET 1 OF 1
DATE 05.12.05	TITLE BUSHING SCALE 2:1		
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

RELEASED

05.12.05 *[Signature]*



SHOP
RIE
ENGINE
UNCONTROL
SUBJECT TO
WITHOUT
WORK

D3454-X

1) SPECIFICATION: D3454-X BUSHING

NO. *77616 M.L.J*
11/12/13

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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